



Dart Aerospace Ltd.
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D5560-1
Job Sheet 182396



Part No: D5560-1

Job Qty: 1 ea

DAS
21
9-89

Part Name: Bearpaw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/23/18

Job Tracking No:

Due Date: 9/14/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: Dwg D5560-1 Rev.B IPP REV. A NEW ISSUE 17/10/17 JFS VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	9/14/18	9/14/18	0.00	0.00	Start Up Waterjet		OK 18/08/2018
120	Waterjet	10 pcs	9/14/18	9/14/18	0.00	3.39	Waterjet 2 OMAX		OK 18/08/2018
130	CNC Vertical Machining	10 pcs	9/14/18	9/14/18	0.66	16.39	HAAS1-1		DIP 18-08-31
140	QC	10 pcs	9/14/18	9/14/18	0.00	0.00	QC2 Machining-4		DIP 18-08-31
150	QC	10 pcs	9/14/18	9/14/18	0.00	0.00	QC8 Machining-4		18-9-11
151	Packaging	10 pcs	9/14/18	9/14/18	0.00	0.00	Packaging3		
190	QC21-SA	10 Ea	9/14/18	9/14/18	0.00	0.00	QC21		SEP 11 2018

Part Op 120 - Cut Blank as per File D5560-1_BLANK

Descriptions: 130 - Note: (2) Bearpaw for (1) Kit 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FB624 and Dwg D5560 3-Deburr

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	33.4000 sf (3.34 ea)	90-Start up Operation	50455912

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MUHMWB10	33	1,051	0

Part Specifications

Specifications could not be found.



Container No: S105257



Part: D5560-1

Job No: 182396

Serial No/Batch: S105257

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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Date: 08/26/18

DART AEROSPACE LTD		Work Order:	182396
Description:		Part Number:	D5500-1
Inspection Dwg:	Rev:	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.250	$\pm .010$	4.250	✓		Vern	
0.250	$\pm .020$	0.254	✓		"	
Ø 0.266	$+ .006 / - .001$	0.265	✓		G.P.	
Ø 0.750	$+ .008 / - .001$	0.752	✓		Vern	
R 0.25	$\pm .030$	0.250	✓		R.G.	
0.300	$\pm .015$	0.305	✓		P.G.	
Ø 0.930	$\pm .010$	0.931	✓		Vern	
0.380	$+ .030 / - .000$	0.388	✓		"	
.06 x 45°	$\pm .030 / \pm 1/2^\circ$	0.075 x 45°	✓		"	
0.250	$+ .030 / - .000$	0.259	✓		"	
11.75	$\pm .030$	11.750	✓			
R 0.25	$\pm .030$	0.250	✓		R.G.	
0.30 x 45°	$\pm .030 / \pm 1/2^\circ$	0.300 x 45°	✓		Vern	
0.750	$\pm .030$	0.755	✓		"	
0.63	$\pm .030$	0.625	✓		"	
0.95	$\pm .030$	0.954	✓		"	
19.00	$\pm .030$	19.00	✓		"	
0.38	$\pm .030$	0.380	✓		"	
5.500	$\pm .010$	5.500	✓		"	
9.000	$\pm .010$	9.000	✓		"	
3.000	$\pm .010$	3.000	✓		"	
1.75	$+ .000 / - .030$	1.750	✓		"	

Measured by:	DJP	Checked by:	JK	QC Inspector:	
Date:	18-08-29	Date:	18-9-11	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					